

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013179**Date Inspected:** 09-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector witness ZPMC MT personnel performed MT on various temporary attachments base metal repair areas on CB 8. The member(s) is/are identified as Punch List Item 378 attachments locations.

CB8

1. SP205A

7BW+7CW

Shield Metal Arc Welding (SMAW) VT repair welding was performed on various stiffeners located on the side plate cross beam side of segment. Welder is identified as Mr. Xu Changxue (066002). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBW7B bottom plate of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR11780 repair procedure.

Y Location of repairs areas by above noted welder (045196) is located at 3200mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBW7B bottom plate of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR11780 repair procedure.

Y Location of repairs areas by above noted welder (045221) is located at 3780mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBW7B bottom plate of segment. Welder is identified as Mr. Xu Changxue (066002). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR11780 repair procedure.

Y Location of repairs areas by above noted welder (066002) is located at 5330mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 007 located at OBW7B counter weight side of segment. Welder is identified as Mr. Chen Hongjun (067609). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR11780 repair procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at OBW7B counter weight side of segment. Welder is identified as Mr. Wang Changming (047864). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR11778 repair procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at OBW7B counter weight side of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR11778 repair procedure.

7AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 029 located at SEG033B counter weight of segment. Welder is identified as Mr. Xu Zichuan (205098). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214.

Miscellaneous Work In Progress

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QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

7BW+7CW

1. Ut reject excavation in progress at the side plate to side plate weld joint OBW7B-007 located counter weight side of segment. Y locations are as followed: 200mm, 1700mm, 2690mm, 3000mm, 3780mm, 4200mm, 4770mm, 4880mm, 5330mm, 6120mm and 7380mm.

7BE

1. Ut reject excavation in progress of weld joint SEG036C-043 located at the LD to FB web bike path side of segment. Y locations are as followed: 100mm

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
Reviewed By:	Miller, Mark	QA Reviewer
